



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2893-1
Job Sheet 212334



Part No: D2893-1

Job Qty: 10 pcs *8 pcs inf*

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/20/20

Job Tracking No:

Due Date: 9/23/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2893 REV D IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E
Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15
add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C ver:ECDWG /IPP Rev. I 19.10.01 New
issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	HAAS 4 Axis	10 pcs	9/22/20		2.00	25.00	HAAS - 1	<i>20/09/20</i>
							HAAS - 2	
							HAAS - 3	
							HAAS - 4	
120	QC 8	10 pcs	9/22/20		0.00	0.00	QC 8 - 12	<i>20-09-20</i>
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	



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CANADA
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Container No: S300876



Part: D2893-1

Job No: 212334

Serial No/Batch: S300876

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/16/20

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					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
130	Crosstubes - 2 - B4B	10 pcs	9/23/20	0.00 1.67	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	DAS
					Crosstubes - 4 - B4B	41 SEP 21 2020 9-89
140	QC 3	10 pcs	9/23/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	SEP 22 2020 DAS
					QC 3 - 19	40 9-89
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
					QC 3 - 47	
170	Packaging 3-1 - Stock - B4B	10 pcs	9/23/20	0.00 0.00	Packaging 3 - 1 - B4B	
		8 pcs M/L			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28 9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	SEP 22 2020
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	

					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
180	QC 21 - SA	10 pcs	9/23/20	0.00 0.00	QC 21 - SA - 21	DAS 21
					QC 21 - SA - 70	SEP 22 2020
					Broussard	
					QC 21 - SA - 9	
					QC 21 - SA - 77	

Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and use DT10660 apply 3M Scotch-Weld as per dwg. S206999 c xp 8/31

140 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location:) LOCATION : LG050

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	5 pcs (.5 ea)	100-HAAS 4 Axis	5298677

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	5	12	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

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DART AEROSPACE LTD		Work Order: 212334
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.125	0.160		.140	.147	.145	.145	.142
AB	0.040	0.060		.051	.049	.042	.055	.057
AC	Ø0.260	Ø0.266		.262	.262	.262	.262	.262
AD	Ø0.187	Ø0.143		.187	.187	.187	.187	.187
AE	0.240	0.250		.250	.250	.250	.250	.250
AF	1.347	1.407		1.370	1.369	1.366	1.370	1.370
AG	1.200	1.240		1.205	1.205	1.205	1.203	1.208
AH	0.147	0.167		.165	.162	.161	.165	.162
AI	2.985	3.005		2.995	3.000	2.998	2.998	2.998
AJ	0.400	0.500		.470	.480	.475	.475	.480
AK	4.930	4.990		4.955	4.955	4.955	4.955	4.955
AL	0.125	0.160		.140	.140	.140	.140	.140
AM	R0.053	R0.073		.06	.06	.06	.06	.06
AN	R0.240	R0.260		.250	.250	.250	.250	.250
AO	R0.021	R0.041		.031	.031	.031	.031	.031
AP	0.150	0.180		.179	.178	.178	.176	.175
AQ	0.053	0.073		.062	.062	.062	.062	.062
AR	2.302	2.322		2.317	2.317	2.320	2.315	2.315
AS	0.140	0.160		.152	.152	.150	.143	.147
AT	0.040	0.060		.047	.050	.050	.047	.051
Accept/Reject								

Measured by: <i>[Signature]</i> 20/09/16	Date:
Audited by: DAS 20 20-09-20	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	
E	20.02.10	Dwg Rev and Dimensions updated.	MG <i>[Signature]</i>	DP <i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	212354
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	7	8	4	5
HAAS Section								
AA	0.125	0.160		.142	.140	.135		
AB	0.040	0.060		.057	.050	.057		
AC	Ø0.260	Ø0.266		.262	.262	.262		
AD	Ø0.187	Ø0.143		.187	.157	.187		
AE	0.240	0.250		.250	.250	.250		
AF	1.347	1.407		1.373	1.372	1.373		
AG	1.200	1.240		1.210	1.207	1.213		
AH	0.147	0.167		.162	.165	.162		
AI	2.985	3.005		2.998	2.997	2.994		
AJ	0.400	0.500		.480	.486	.480		
AK	4.930	4.990		4.955	4.955	4.955		
AL	0.125	0.160		.141	.140	.140		
AM	R0.053	R0.073		.062	.062	.062		
AN	R0.240	R0.260		.250	.250	.250		
AO	R0.021	R0.041		.031	.031	.031		
AP	0.150	0.180		.178	.177	.177		
AQ	0.053	0.073		.062	.062	.062		
AR	2.302	2.322		2.316	2.315	2.317		
AS	0.140	0.160		.145	.145	.147		
AT	0.040	0.060		.050	.046	.052		
Accept/Reject								

Measured by:	DAS 20/09/16	Date:	
Audited by:	20 20-09-20 9-89	Date:	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
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C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	
E	20.02.10	Dwg Rev and Dimensions updated.	MG	DP

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					